



Dart Aerospace Ltd.
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RBW2905G00232-3G-7
Job Sheet 172359



Part No: RBW2905G00232-3G-7

Job Qty: 4 ea

Part Name: Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/15/18

Job Tracking No:

Due Date: 2/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW2905G00232-3G REV 2 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/27/18	0.00	0.00	Start Up Small Fab-4		FF
100	Small Fab	4 pcs		2/28/18	0.00	1.00	Small Fab-9		FF
110	QC	4 pcs		2/28/18	0.00	0.00	QC5		DAS JB
130	Packaging	4 pcs		2/28/18	0.00	0.00	Packaging3-2		21 SB
140	QC21-SA	4 Ea		2/28/18	0.00	0.00	QC21		9.20 MAR 29 2018

Part Op 100 - 1- Bend tube as per DWG 2- Assemble as per DWG RBW2905G00232-3G 3-Flare tube end for #8 flare fitting
Descriptions: 130 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW2905G00232-3G-9	Tube	4 Ea (1 ea)	90-Start up Operation	5017138
8 BTX-S	Flare Nut, Steel	4 (1 ea)	100-Small Fab	5052240
8 TX-S	Sleeve	4 (1 ea)	100-Small Fab	5052241

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW2905G00232-3G-9	4	0	0
100-Small Fab	8 BTX-S	4	0	0
	8 TX-S	4	0	0

Part Specifications

Specifications could not be found.

Plex 2/15/18 3:04 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	Susp.
Part No. _____	
NCR No. _____	

Date : _____ Step #: _____

Description Work Order Deviat

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Work Order update only ☐

Container No: S056285
Part: RBW2905G00232 - 3G-7
Job No: 172359
Serial No/Batch: S056285
Revision: 2
Inspector: _____

Date: 03/29/18

DART
 AEROSPACE

Engineering ☐
 Quality ☐
 Other ☐

(QSI042) Approval

Completed By

Hand / Supervisor
 Approval Verification

QA Coordinator
 Approval

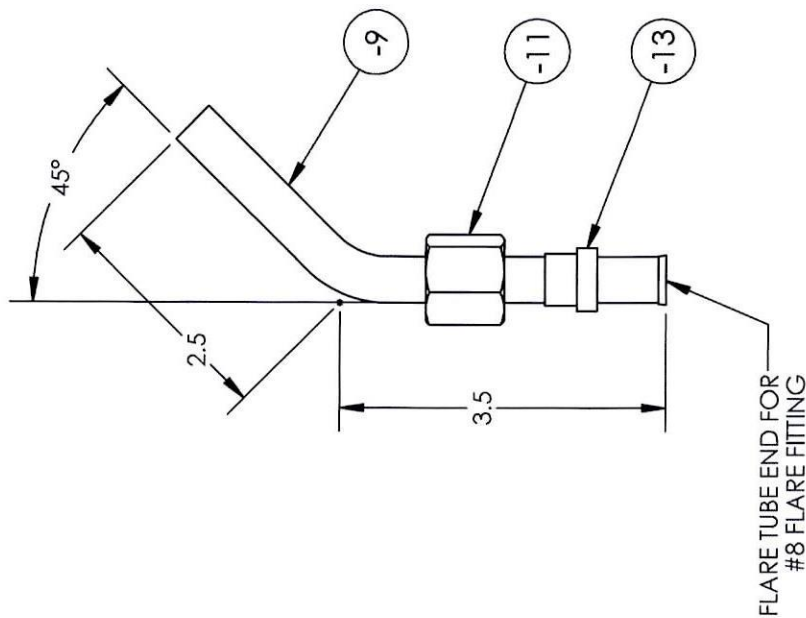
1270 American Street
 Harrisburg, PA 17104
 Tel: 717.651.8321
 Email: sales@dartaero.com
 Web: dartaero.com

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172359 HCS
18-02-15



TITLE
ADAPTER ASSY, PCM RETURN LINE

DWG NO. RBW2905G00232-3G-7 REV 2

MAT'L	DRAWN BY: GILBERT	APPROVED	2
UNLESS OTHERWISE SPECIFIED			
DIMENSIONS ARE IN INCHES			
.XXX ± .005	REAT	2	Well
.XX ± .01	TREAT		
.X ± .1	FINISH		
ANGLES ± 5°			
SPEC			
1. BREAK ALL SHARP EDGES .015 x 45°			
OR .018R			
2. DIMENSIONAL LIMITS APPLY AFTER			
PLATING			
SCALE 1:4	DATE 3/3/2011	USED ON MODEL	AGUSTA AW139
SHEET 2 OF 2			

(7)

TUBE ASSEMBLY

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :	Step #:	QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				Completed By	
						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____	